

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021678**Date Inspected:** 20-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that in Bay 8 ZPMC was in the process of heat straightening. ZPMC Quality Control inspector Liu Chuan Gang was present at the time of this observation and informed this QA inspector of the work in process and identified Liu Fa Wen as the Certified Welding Inspector (CWI). It was stated that ZPMC had 1 worker performing Heat Straightening in accordance with HSR1-(B)10084 on bike path BK004A2-063 bottom plate.

Bay 3

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 3 ZPMC was in process of SMAW welding on Architectural Housing subassembly AH3150. ZPMC CWI Wang Liang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder that performed fit-up and tack welding and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Edge Plate EP3017A

WPS-B-P-2312-TC-P4

Welder-058102

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2G//SMAW/PJP

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 10 ZPMC was in process of FCAW (ESAB) welding on Tower Head Cover subassembly. ZPMC QC inspector Wang Chuang Xin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Yu Dong Ping as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

(WR20158)

Weld- NSD1-DPSA6-4

WPS-B-T-2232-ESAB

Welder-040434

2G//FCAW/CJP

This QA inspector observed in process SMAW welding on bike path assembly BK008A3-001-010. ZPMC QC inspector Wang Chuang Xin was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld-BK008A3-001-010

WPS-345-SMAW-1G(1F)-Repair

Welder-057258

1G//SMAW/CJP

This QA inspector observed in process SMAW welding on bike path cantilever beam assembly BK15A. ZPMC CWI inspector Yu Dong Ping was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- Tack Welding Interior Plate

WPS-B-P2112

Welder-050038

2F//SMAW

This QA inspector observed ZPMC personnel performing Heat Straightening (HSR1 B 10101) on traveler rail 3005TR1, 3005TR2 and 3005TR3. ZPMC CWI inspector Yu Dong Ping was present at this time of this observation and informed this QA inspector of the work that is in process.

Trial Assembly

This QA inspector performed a random observation for the OBG. During the observation performed it was noted

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that at Trial Assembly ZPMC was in process of welding on 12BE + 12CE and 12AE/CB17. ZPMC QC inspector Song Hui was present at this time of this observation and informed this QA inspector of the work that is in process.

It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to them by ZPMC. This QA inspector verified this information for the following location;

12BE + 12CE

Weld- DP3018-001-021

WPS-B-P-2214-TC-U4b-FCM-1

Welder-040320

1G//SMAW/CJP

12AE/CB17

Weld- BP3017—017-024

WPS-B-T-2132-ESAB

Welder-040367

2F/FCAW

12AE/CB17

Weld- BP3017—017-025

WPS-B-T-2132-ESAB

Welder-047353

2F/FCAW

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike
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Quality Assurance Inspector

Reviewed By:	Riley, Ken
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QA Reviewer
